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D212-664-107B
Job Sheet 183624



Part No: D212-664-107B

Job Qty: 1 ea

Part Name: Fwd Crosstube - Low Standard



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/21/18

Job Tracking No:

Due Date: 9/26/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG REV C/IIN-D212-664 REV.J IPP REV:A 13.09.16 DWG REV.B DD VERF:JLM IPP REV:B 14.02.12 AS
PER DSI9680 REVA DD VERF:JLM

Ship Via:

Bill of Materials



Container No: S112702



Part: D212 - 664 - 107B

Job No: 183624

Serial No/Batch: S112702

Revision: C/J

Inspector:

Exp Date:

Instructions: TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC SR01298NY 09/01/08

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PATENT	N/A	CHG	CHG004
P/N	D212-664-107	STC	SH01-9
DESC.	Crosstube Std Fwd	STC	SR01298NY
LOT	B155632	STC	
MODEL	Rev 204/205/210/212/214/412/UH-1	STC	
TC APPROVAL # 09-89		MADE IN CANADA	
		D2729-4	

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	9/26/18	9/26/18	0.00	0.00	Start Up Crosstubes-1		AS SEP 20 2018
110	Packaging	1 pcs	9/26/18	9/26/18	0.00	0.00			NR
120	CNC Bend Crosstubes	1 pcs	9/26/18	9/26/18	0.00	2.51	CNC Bend Crosstube		
130	QC	1 pcs	9/26/18	9/26/18	0.00	0.00	QC15		
140	Crosstubes	1 pcs	9/26/18	9/26/18	0.00	0.31	Crosstubes-1		
160	HandFXtube	1 pcs	9/26/18	9/26/18	0.00	0.00	HandFinish5		
165	QC	1 pcs	9/26/18	9/26/18	0.00	0.00	QC5		
170	QC	1 pcs	9/26/18	9/26/18	0.00	0.00	QC7-1		
180	Outsource	1 pcs	9/26/18	9/26/18	0.00	0.00	Outsource2		
190	Packaging	1 pcs	9/26/18	9/26/18	0.00	0.00	Packaging2		
200	QC	1 pcs	9/26/18	9/26/18	0.00	0.00	QC5		
210	Crosstubes	1 pcs	9/26/18	9/26/18	0.00	0.31	Crosstubes-1		
215	QC	1 pcs	9/26/18	9/26/18	0.00	0.00	QC5		
220	SprayPaint	1 pcs	9/26/18	9/26/18	0.00	0.00	Spray Paint		
230	QC	1 pcs	9/26/18	9/26/18	0.00	0.00	QC14		N/R
240	Crosstubes	1 pcs	9/26/18	9/26/18	0.00	0.31	Crosstubes-1		AS SEP 20 2018
250	QC	1 pcs	9/26/18	9/26/18	0.00	0.00	QC5		38
255	Packaging	1 pcs	9/26/18	9/26/18	0.00	0.00			389
260	QC	1 pcs	9/26/18	9/26/18	0.00	0.00	QC4		
270	Packaging	1 pcs	9/26/18	9/26/18	0.00	0.00	Packaging3-1		
275	DC	1 pcs	9/26/18	9/26/18	0.00	0.00	DC		MCS 18-09-29
280	QC21-FG	1 Ea	9/26/18	9/26/18	0.00	0.00	QC21		MCS 18-09-29

Part Op 120 - Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

Descriptions: 140 - 1-Cut tube as per inspection dwg. ***ensure saw is square*** 2-Drill pilot holes in tube as per Dwg D212-664-147 3-Drill Rivet holes as per Dwg D212-664-147 using DT8972. 4-Ream hole to finish size in tube as per Dwg D212-664-147 5-*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-147

160 - ***IMMEDIATELY AFTER GRINDING*** 1- PRESSURE WASH X-TUBE INSIDE AND OUT 2- ALODINE AND ACID ETCH X-TUBE INSIDE AND OUT AS PER QSI005.

180 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order

190 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Ensure copy of NDT results attached to work order.

200 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Inspect for damage & ensure results are as per Dwg D412-664-203

210 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** 1-Rivet Cuffs as per Dwg D212-664-147. with Sika flex in Between tube & Cuff A/R SIKAFLEX -241/-291 BATCH: _____

220 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____ ***MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per QSI 005 4.2 PRIMER: _____ START TIME: _____ FINISH TIME: _____ 2-Paint outside crosstube with White Imron as per QSI 005 4.2 PAINT: Start Time: _____ Finish Time: _____

230 - Wrap in plastic bag to protect from scratches ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____

240 - Assemble as per Dwg D212-664-147 *****LAY DOWN CORSTUBE ON TABLE AND PUT DT10302 PINS IN SADDLE HOLE FACING UP, USE HOLE IN TAPE MESURE TO PUT IN PINS FOR LOCATING CENTER OF CROSSTUBE. ***** 1- Abrade mating surfaces of support and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg 2- Install supports with Proseal 890 per D212-664-147 and QSI 015 A/R Proseal 890 Batch: 9096394 EXP: 3/19 PROSEAL CURE TIME 72 HOURS: Start: 18-9-20 Finish: 18-9-23 3- Install clamps with rubber cushion (ENSURE CLAMPS ARE INSTALL ON TOP SIDE OF CROSSTUBE) as per Dwg D212-664-147. ***Torque all clamps to 80-100 IN-LBS.***

250 - ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.*** ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____

260 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____

270 - Identify and pack for shipping as per PPP D212-664-107b

275 - Photocopy bluefile and create labels as per PPP D212-664-107b CHG 004

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN6-35A	Bolt	4 Ea (4 ea)	90-Start up Operation	S112565
AN6-36A	Bolt	4 Ea (4 ea)	90-Start up Operation	S112566
CR3212-4-06	Rivet	44 Ea (44 ea)	90-Start up Operation	S112567
D212-664-107TRN	Crosstube Turning Detail	1 Ea (1 ea)	90-Start up Operation	S112571
D3428-1	Placard	1 Ea (1 ea)	90-Start up Operation	S112573
D3595-063-450	Rubber Cushion 0.63" Wide X 4.50" Long	4 Ea (4 ea)	90-Start up Operation	
D3659-1	Cuff	2 Ea (2 ea)	90-Start up Operation	S112575
D5017-1	Support, 214 Fwd	2 Ea (2 ea)	90-Start up Operation	
MS21042L6	Nut	6 Ea (6 ea)	90-Start up Operation	S112568
MS21920-25	Clamp	4 Ea (4 ea)	90-Start up Operation	
NAS1149D0663J	Washer	18 Ea (18 ea)	90-Start up Operation	S112570

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN6-35A	4	71	0
	AN6-36A	4	113	0
	CR3212-4-06	44	277	0
	D212-664-107TRN	1	5	0
	D3428-1	1	28	0
	D3595-063-450 S078312	④	111	0
	D3659-1	2	4	0
	D5017-1 F130698-0	②	8	0
	MS21042L6	6	458	0
	MS21920-25 S082848	④	210	0
	NAS1149D0663J	18	1,328	0

Part Specifications

Specifications could not be found.

Plex 9/21/18 2:23 PM dart.white.jesse